

TECHNICAL DATA

Standards

DIN Material Nr. 1.3348

DIN EN 14700 :	S Fe4
AWS A5.21 :	ERFe-6 mod.

General Properties / Field of Applications

DSI M 10Plus is a martensitic Chrome steel Laser Welding Wire with good heat strength up to 500°C. Scale resistant up to 800°C. High resistance against adhesive and abrasive wear. Resists impact stress and hardenable. For highly wear resistant welding on cutting and bending tools. Weld can be machined after soft annealing, otherwise only machinable by grinding.

Mechanical Properties

Hardness untreated	[HRC]	55 - 63
Soft annealed (780°C - 820°C, 2-4 H)	[HRC]	27
Hardened (compressed air 1,180°C - 1,220°C)	[HRC]	63
Tempered twice (540°C-560°C, 1H, air)	[HRC]	65

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Mo	V	W
1.0	0.4	0.3	3.9	8.4	1.9	1.8

Compatible Materials (Selection)

SKD11 / HPM31 / GGG70L / DC53 / SKH51 / Z160CDV12 / Vanadis23 / Vanadis30
ASP23 / ASP30 / Toolox33 / High speed cutting tools / 1.2379 / 1.2363 / 1.2080

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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